

Work Order ID 54467

December 09, 2009 1:38:53 PM



Page 1

Item ID: D2918-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH

Start Date: 12/10/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 12/28/2009 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *mf*

Date: *09-12-09* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2918	Rev B

100		0.00							
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HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number ☐ Machine Step No 1 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet ☐ Machine Step No 2 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet ☐ Machine Step No 3 as per Folio

DTP
10/01/05

8 0

110		0.00							
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CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per Dwg D2918 & attached dimension sheet

DTP
10/01/06

8 0

120		0.00							
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QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DTP
10/01/06

8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Required Date: 12/28/2009	Req'd Qty: 8.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		ent 10/01/07		8	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		BR 10-01-07.		8	0		
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 11113170 Memo START TIME: 7:45am 8:15am FINISH TIME: 3:20p	0.00 0.00		=> 10-01-12		8	0		

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Setup Start

Revision ID:

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Item Name: Saddle LH

Start Date: 12/10/2009 Start Qty: 8.00

Cust Item ID:

Required Date: 12/28/2009 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

BR 10-01-12

(8)

170

Identify as per dwg & Stock Location: ~~25~~

0.00

Packaging

Memo

0.00

Packaging

10-1-12

80 SF

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/15

MF 10-1-12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Page 1

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Work Order ID: 54467



Parent Item: D2918-1



Parent Item Name: Saddle LH

Start Date: 12/10/2009

Required Date: 12/28/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-011		Manufactured	No			100	Each	14.0000	8.0000			



Saddle Billet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	14	
52068	4	
53520	10	

8 ISS 10/01/05

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NOTE: Date & initial all entries

Inspect dimensions highlighted on inspection sheet drawing and record below:

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	08.02.28	Dimension 'R' revised	KJ/DD	
C	08.11.27	Dimension 'AB, AC' added	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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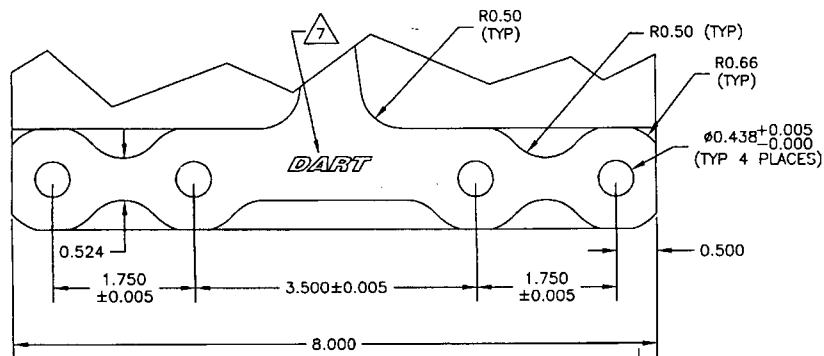
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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#54467

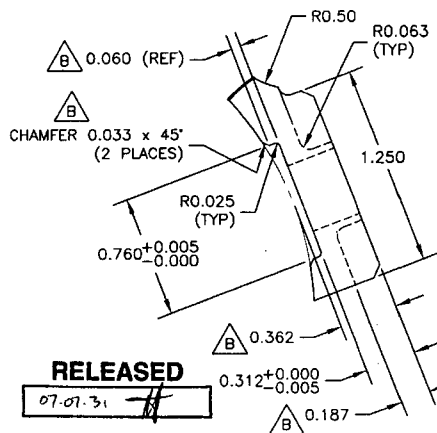


VIEW B-B

D2918-1 LH SADDLE (SHOWN)
D2918-2 RH SADDLE (OPPOSITE)

NOTES:

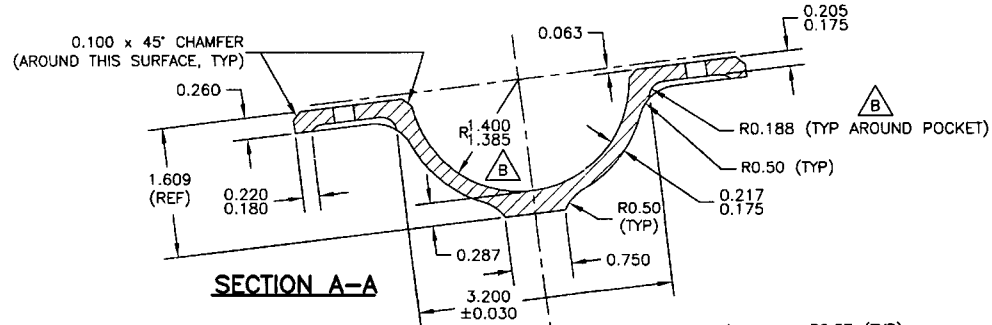
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



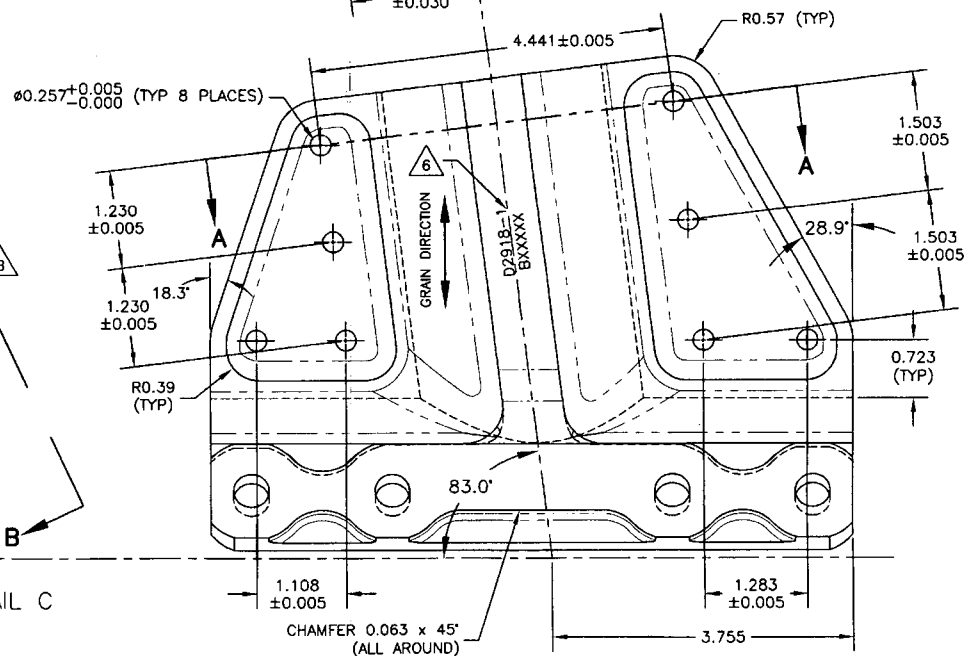
RELEASED

07-07-31

DETAIL C
SCALE 4:3



SECTION A-A



B	07.02.19	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	90	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.02.19	TITLE
		SADDLE

DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D2918	REV. B SHEET 1 OF 1
SCALE	2:3

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